

Date: Thursday, 20/11/2008 11:43:02 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 43565
 Estimate Number : 10531
 P.O. Number :
 This Issue : 20/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2572UP
 Drawing Number : D2572 REV E
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : E
 Previous Run : 42803 Material :
 Due Date : 04/12/2008 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : JLD 08.11.20
 Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101005 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2572

Ensure that grain is along 5.00" length

Batch No: 34874

DTP 08/12/02

6

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 43565 Double check by: JLD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

DTP 08/12/02 / J.L 08/12/05 6

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

J.L 08/12/05 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 08/12/2008 7:20:15 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 43565

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK *hl*



Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 08/12/08

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

OLIVE DRAB GREEN

M104476

M-L 08/12/08

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-12-08 - Cox

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *425*

8/12/08

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-08

Date: Thursday, 20/11/2008 11:43:03 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 43565

Part Number: D2572UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IL 08/12/05 (7)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/12/06 (6)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

See attached n

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------------------------|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 43565 |
| Description: Saddle, Fwd Inboard | | Part Number: D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | | 0.440 | .440 | .440 | .440 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.0045 | 7.999 | 7.999 | 8.001 | | |
| F | 0.490 | 0.510 | | 0.499 | .499 | .501 | .500 | | |
| G | 0.257 | 0.262 | | 0.259 | .258 | .258 | .258 | | |
| H | 0.375 | 0.380 | | 0.376 | .376 | .376 | .376 | | |
| I | 0.490 | 0.510 | | 0.502 | .501 | .501 | .502 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | 0.5675 | .567 | .567 | .568 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.490 | 1.500 | | 1.495 | 1.495 | 1.495 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.874 | | |
| P | 0.115 | 0.135 | | 0.125 | .124 | .124 | .122 | | |
| Q | 0.115 | 0.135 | | 0.135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | 0.250 | .248 | .249 | .247 | | |
| S | 0.115 | 0.135 | | 0.133 | .131 | .133 | .127 | | |
| T | 0.178 | 0.198 | | 0.187 | .188 | .188 | .188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.237 | .237 | .238 | .235 | | |
| W | 0.115 | 0.135 | | 0.121 | .119 | .126 | .126 | | |
| X | 0.307 | 0.312 | | .308 | .310 | .310 | .310 | | |
| Y | 0.760 | 0.765 | | .760 | .760 | .760 | .760 | | |
| Z | 0.352 | 0.372 | | 0.365 | .366 | .365 | .364 | | |
| AA | 0.470 | 0.530 | | 0.500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | 0.626 | .626 | .625 | .625 | | |
| AC | 0.053 | 0.073 | | 0.062 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | 0.245 | .245 | .247 | .247 | | |
| AE | 1.375 | 1.395 | | 1.388 | 1.390 | 1.389 | 1.388 | | |
| AF | 0.115 | 0.135 | | 0.135 | .135 | .135 | .135 | | |
| AG | 0.240 | 0.280 | | 0.250 | .260 | .260 | .260 | | |
| AH | 0.240 | 0.260 | | 0.249 | .246 | .248 | .247 | | |
| AI | 2.000 | 2.020 | | 2.004 | 2.003 | 2.003 | 2.002 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|----------|
| Measured by: | DTP |
| Date: | 08/12/03 |

| | |
|-------------|----------|
| Audited by: | JLM |
| Date: | 08/12/06 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------------|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | | |
|-----------------------------------------|--|---------------------|-------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: Saddle, Fwd Inboard | | Part Number: | D2572 |
| Inspection Dwg: D2572 Rev. E | | Page 1 of 1 | |

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

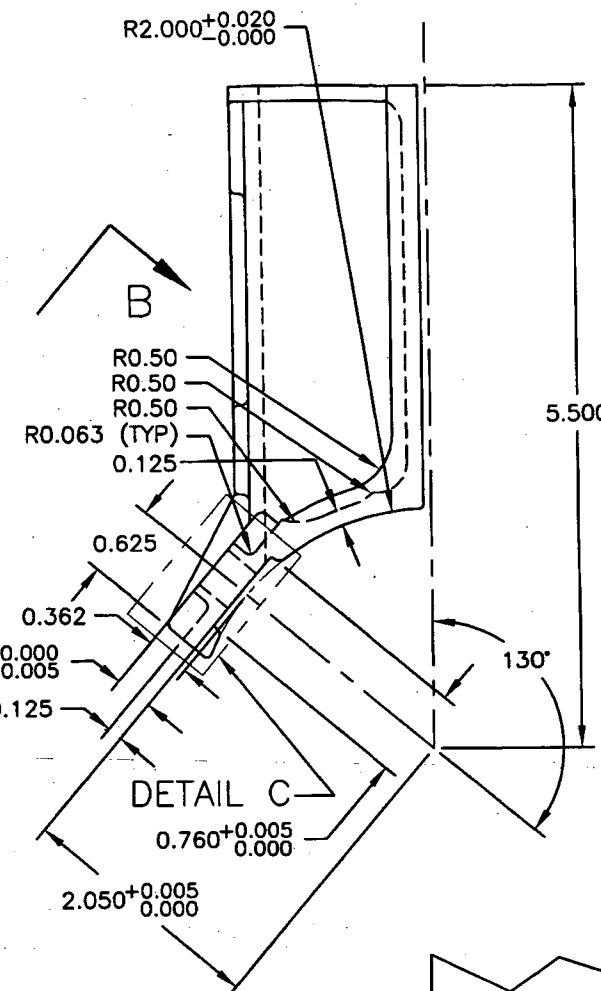
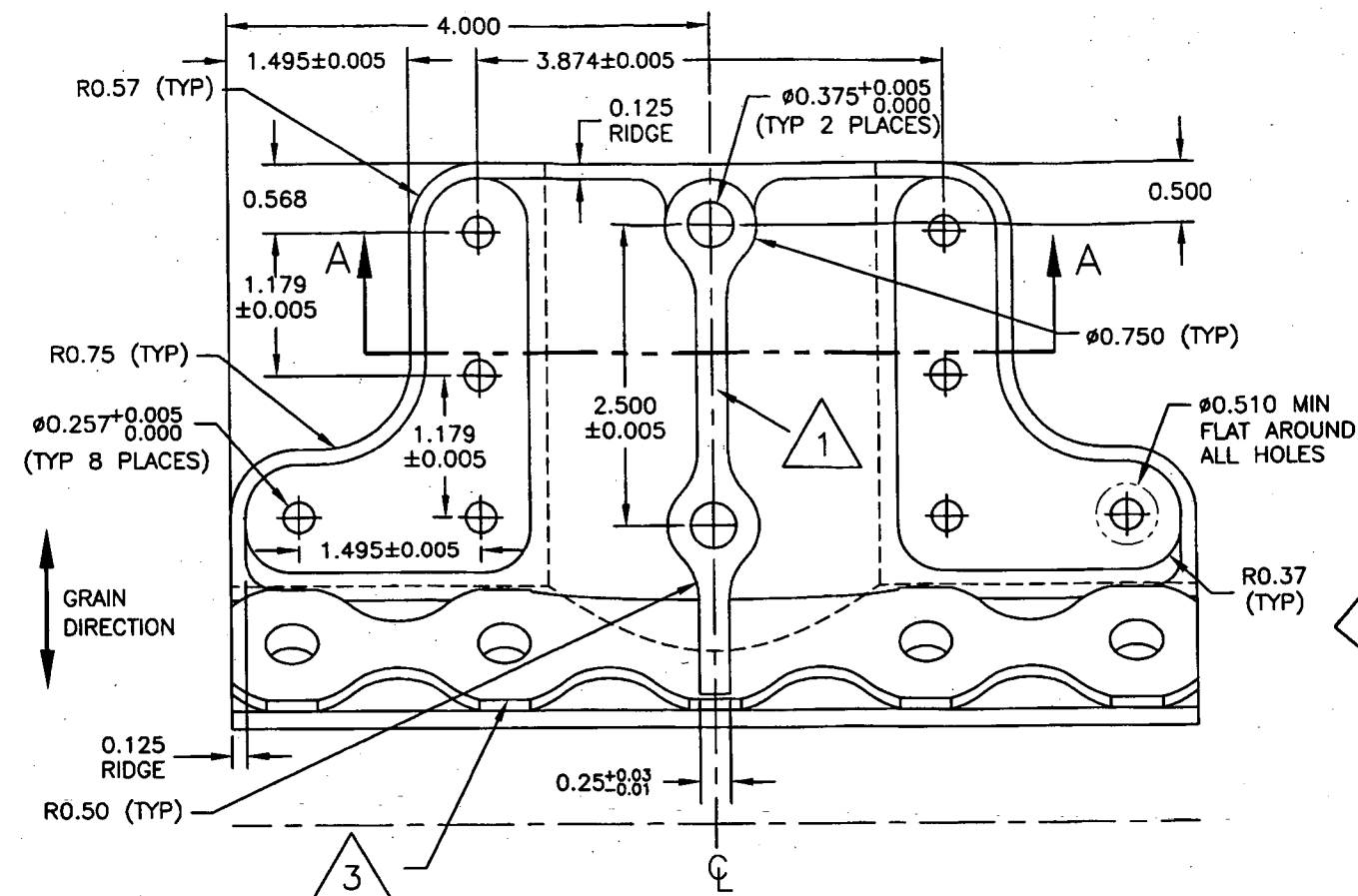
| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 15 | 16 | 3 | 4 | | |
| A | 0.438 | 0.443 | | .440 | .440 | | | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | | | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | | | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | | | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | | | | |
| F | 0.490 | 0.510 | | .499 | .499 | | | | |
| G | 0.257 | 0.262 | | .258 | .258 | | | | |
| H | 0.375 | 0.380 | | .376 | .376 | | | | |
| I | 0.490 | 0.510 | | .500 | .500 | | | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | | | | |
| K | 0.558 | 0.578 | | .569 | .569 | | | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | | | | |
| M | 1.490 | 1.500 | | 1.495 | 1.495 | | | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | | | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | | | | |
| P | 0.115 | 0.135 | | .123 | .123 | | | | |
| Q | 0.115 | 0.135 | | .135 | .135 | | | | |
| R | 0.240 | 0.260 | | .247 | .247 | | | | |
| S | 0.115 | 0.135 | | .127 | .127 | | | | |
| T | 0.178 | 0.198 | | .188 | .188 | | | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | | | | |
| V | 0.230 | 0.250 | | .235 | .235 | | | | |
| W | 0.115 | 0.135 | | .123 | .123 | | | | |
| X | 0.307 | 0.312 | | .310 | .310 | | | | |
| Y | 0.760 | 0.765 | | .760 | .760 | | | | |
| Z | 0.352 | 0.372 | | .365 | .365 | | | | |
| AA | 0.470 | 0.530 | | .500 | .500 | | | | |
| AB | 0.615 | 0.635 | | .624 | .624 | | | | |
| AC | 0.053 | 0.073 | | .063 | .063 | | | | |
| AD | 0.240 | 0.260 | | .244 | .244 | | | | |
| AE | 1.375 | 1.395 | | 1.392 | 1.392 | | | | |
| AF | 0.115 | 0.135 | | .135 | .135 | | | | |
| AG | 0.240 | 0.280 | | .260 | .260 | | | | |
| AH | 0.240 | 0.260 | | .246 | .246 | | | | |
| AI | 2.000 | 2.020 | | 2.005 | 2.005 | | | | |
| AJ | 0.023 | 0.043 | | -.033 | -.033 | | | | |
| Accept/Reject | | | | | | | | | |

| | | | |
|--------------|----------|-------------|----------|
| Measured by: | J.L | Audited by: | cmf |
| Date: | 08/12/05 | Date: | 08/12/06 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------------|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

RELEASED

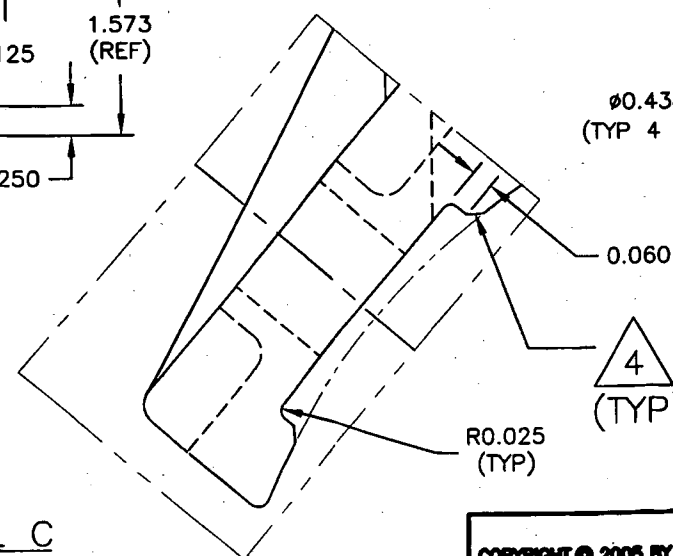
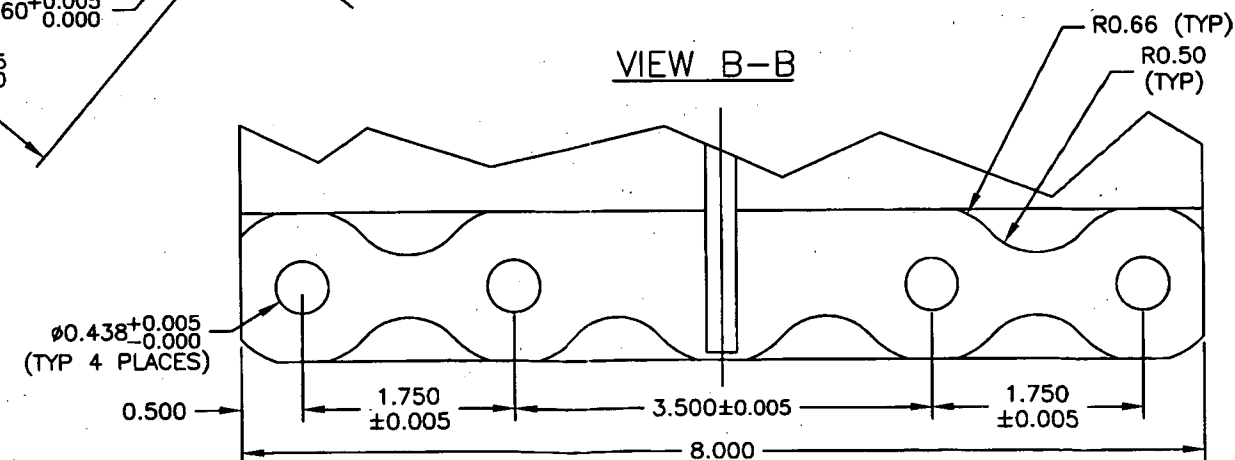
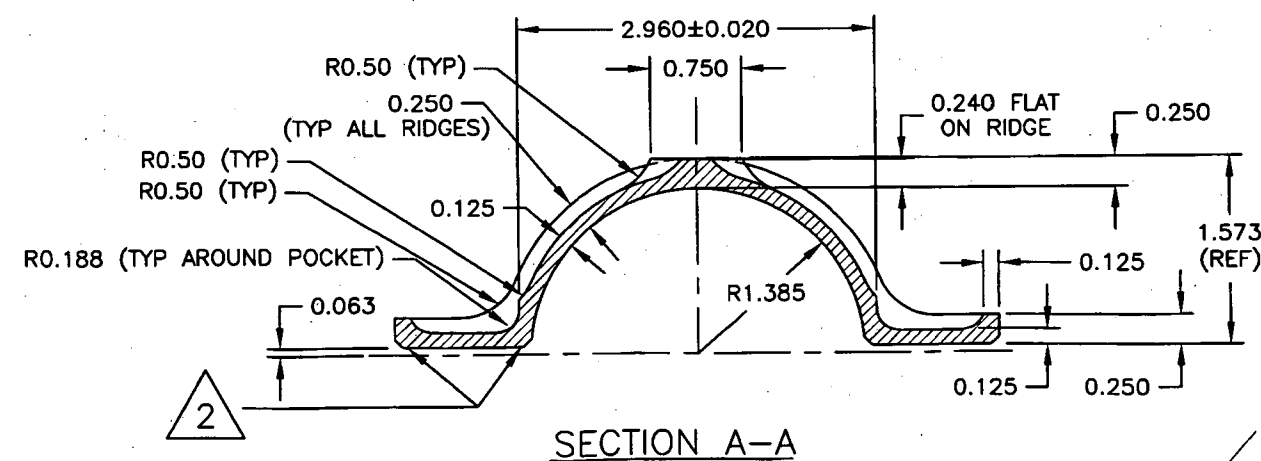
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



DETAIL C
SCALE 2:1

| | | |
|---|----------|------------------------------------------------------------|
| E | 05.07.13 | ADD CHAMFER ON RIDGE NOTE 4 |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES |
| C | 99.10.22 | INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 |
| A | 96.09.16 | NEW ISSUE |

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DART AEROSPACE LTD.

| | | | |
|------------------|---------------------------|----------------------|------------------------------------------------------------------------------------------------------------------------------|
| DESIGN DS | DRAWN BY PH | DART | DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA |
| CHECKED # | APPROVED # | DRAWING NO. D2572 | ENGINEERING REV UNCONTROLLED COPY SHEET 1 OF 1 SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 43365 |
| DATE 05.07.13 | TITLE INNER FWD SADDLE | | |

